

CLUT

~~PRELIMINARY ISSUE~~

10.10.07

Work Order ID 61884-2
Wednesday, September 08, 2010 3:28:15 PM

Item ID: D4177-1

Accept

Revision ID: PRELIM

Item Name: Radalt Guard Doubler

Start Date: 9/8/2010 Start Qty: 5.00

Required Date: 9/13/2010 Req'd Qty: 5.00

Reference:

Approvals: Process Plan:

QC:

Date: 10-9-08

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4177	PA1								
100		0.00							
Waterjet									
FLOW CNC Waterjet	Memo 1-Cut as per Dwg Dwg Rev: PM Prog Rev: PA1 2-Deburr if necessary	0.00							
110									
QC	QC2- Inspect parts off machine FAI/FAIB	0.00							
Quality Control	Memo	0.00							

10-9-13

6

10-9-13

Work Order ID 61884

Wednesday, September 08, 2010 3:28:15 PM

Page 2



Accept



Setup Start



Stop



Item ID: D4177-1

Revision ID: PRELIM

Item Name: Radalt Guard Doubler

Start Date: 9/8/2010 Start Qty: 5.00

Required Date: 9/13/2010 Req'd Qty: 5.00

Reference:

Cust Item ID:

Customer:



Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

-S 10/09/13

0.00

inspected to PM

Day only

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

BR 10-9-14.

0.00

6 4

140



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

2 4 10/09/15

0.00

46 4

Start Time: 2:45pm
Oven Temperature: 320°F
Finish Time: 3:15pm

Work Order ID 61884

Wednesday, September 08, 2010 3:28:15 PM



Page 3

Item ID: D4177-1
Revision ID: PRELIM
Item Name: Radalt Guard Doubler

Accept



Setup Start
Stop



Start Date: 9/8/2010 Start Qty: 5.00
Required Date: 9/13/2010 Req'd Qty: 5.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:

Date:
Date:

Run Start
Stop



SPC (Y/N):

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00 - inspected to PAI
by 10/10/10

0.00 8/10/09/10 (x6)

160



Packaging

Packaging

Identify as per dwg & Stock Location: *composites*

Memo

0.00

0.00

1 pulled

BT 10-10-01 (x4)

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/10/04

10-10-01

POSITIVE RECALL

EFFECTIVE *10/10/01* AUTH *u*

RELEASED *10/10/01* DATE *10.10.01*

PBA released 10.10.01

Picklist Print

Wednesday, September 08, 2010 3:28:22 PM

Page 1

Work Order ID: 61884

Parent Item: D4177-1

Parent Item Name: Radalt Guard Doubler



Start Date: 9/8/2010

Required Date: 9/13/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 10.09.08 new issue verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	104.9340	0.0625	0.328947			



6061-T6 .063 Sheet



10-9-13

Location

MAT21

113608

Loc Qty

104.934

104.934

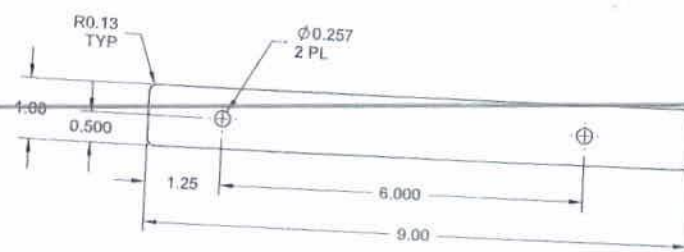
Loc Code

113609

6

Route / Horn / Δxf

None



D4177-1 RADALT GUARD DOUBLER

Q1889
P10 9-09

PRELIMINARY ISSUE
10.09.08

NOTES:

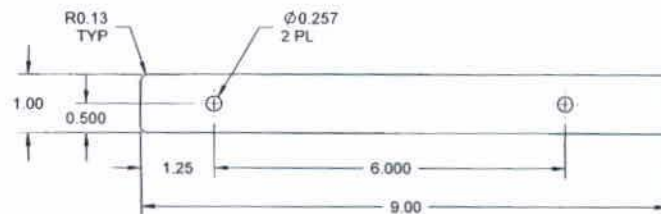
- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANDING" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 005 4.3 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

PA1	NEW ISSUE	MB	10.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4177
REV. PA1
SHEET 1 OF 1
SCALE
NTS

TITLE
RADALT GUARD DOUBLER
COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRELIMINARY AND NOT FOR CONSTRUCTION. IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR CONSTRUCTION OF ANY OTHER PARTS OR EQUIPMENT WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.



D4177-1 RADALT GUARD DOUBLER

NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

RELEASED
2010-09-29
WR

A	NEW ISSUE			MB	10.09.03
REV.		DESCRIPTION			BY DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN		DRAWING NO. D4177			
CHECKED		REV. A SHEET 1 OF 1			
MFG. APPR.		SCALE			
APPROVED		TITLE RADALT GUARD DOUBLER			
DE APPR.		NTS			
DATE	10.09.03	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS ISSUED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR DISSEMINATION TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>			